

**Work Order ID 58129**

Monday, April 26, 2010 11:01:57 AM



Page 1

Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

4

Start Date: 4/26/2010

Start Qty: 12.00



Cust Item ID:

Required Date: 4/30/2010

Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-4-26 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
D3916	A

Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

100

0.00

Large Fab

Memo

0.00

Large Fab

1- Cut tube 50" PD

2- Bend tube with manuel pipe bender as per DT9567 PD

\*\*\* Make line at 9.00" and use jig for other line\*\*\*

3- Drill and chamfer holes as per dwg D3916-1 DT9505 PD

4- Trim access tube material to finish size as per dwg D3916 PD

5- weld bushing as per dwg D3916

6- grind welds flush

GL 10-04-30

110

QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

S10/04/30

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 58129**

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Item ID: D3916-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly

Stop



Start Date: 4/26/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 4/30/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/  
Run Hours

0.00

S. Woulz

Draw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: basket

0.00

Memo

0.00

(4) PD 10.04.30

WRINKLING IN TUBE  
BENDS OK

MF

10/4/30

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/04 JF  
MF 10-5-4

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NOTE: Date & initial all entries

# Picklist Print

Monday, April 26, 2010 11:01:56 AM

Page 1

Work Order ID: 58129



Parent Item: D3916-041



Parent Item Name: Rib Assembly

Start Date: 4/26/2010

Required Date: 4/30/2010

Comments: IPP RevA: New issue DD verified by:EC  
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3759-1 		Manufactured	No			100	Each	21.0000	84.0000		PD 10.04.30	

Bushing

## Warehouse

### Location

Main Warehouse

WA

Loc Qty

Loc Code

~~B58159~~ →

B57852 → 3128

M304TS0.750W.049



Purchased

No

100 f 875.9854 52.6232



PD 10.04.30

304 SQ Tube .75x.75x.049W

## Warehouse

### Location

Main Warehouse

MAT

Loc Qty

Loc Code

200



Main Warehouse

MAT017

675.9853579



Main Warehouse



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

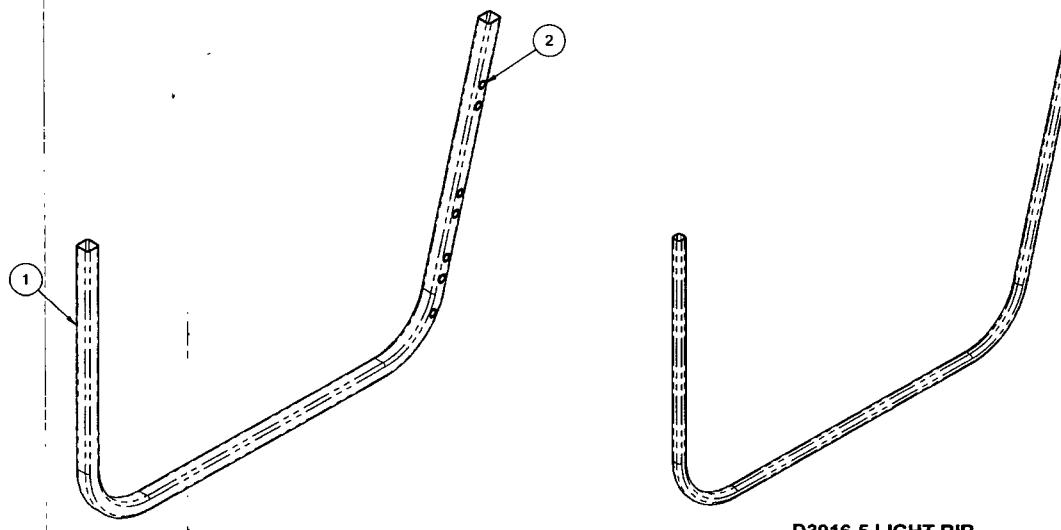
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ITEM	QTY 041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

#58129



RELEASED  
2010-03-12  
JPH

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	PP		REV. A
MFG. APPR.	BB		SHEET 1 OF 4
APPROVED	MM		TITLE
DE APPR.	MM		SCALE
DATE	10.03.04		NTS

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HAWKESBURY, ONTARIO, CANADA

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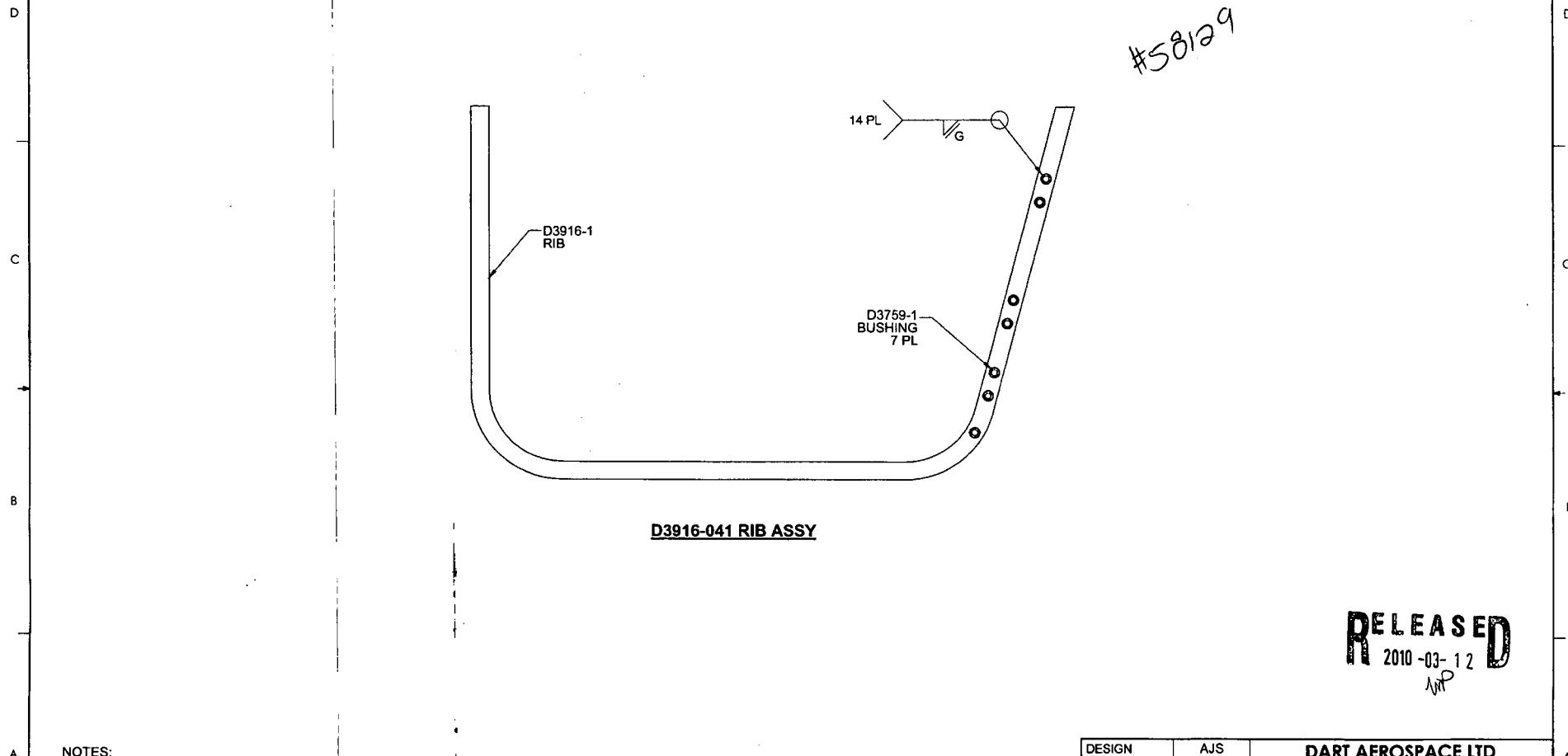
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8 7 6 5 4 3 2 1



NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: NONE  
7) WEIGHT -041: 1.84 lbs  
8) WELD PER DART QSI 004

8 7 6 5 4 3 2 1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PP	DRAWING NO.	
MFG. APPR.	EE	D3916	REV. A
APPROVED	MM	SHEET 2 OF 4	
DE APPR.	MM	TITLE	SCALE
DATE	10.03.04	RIB ASSY, 350 BASKET	

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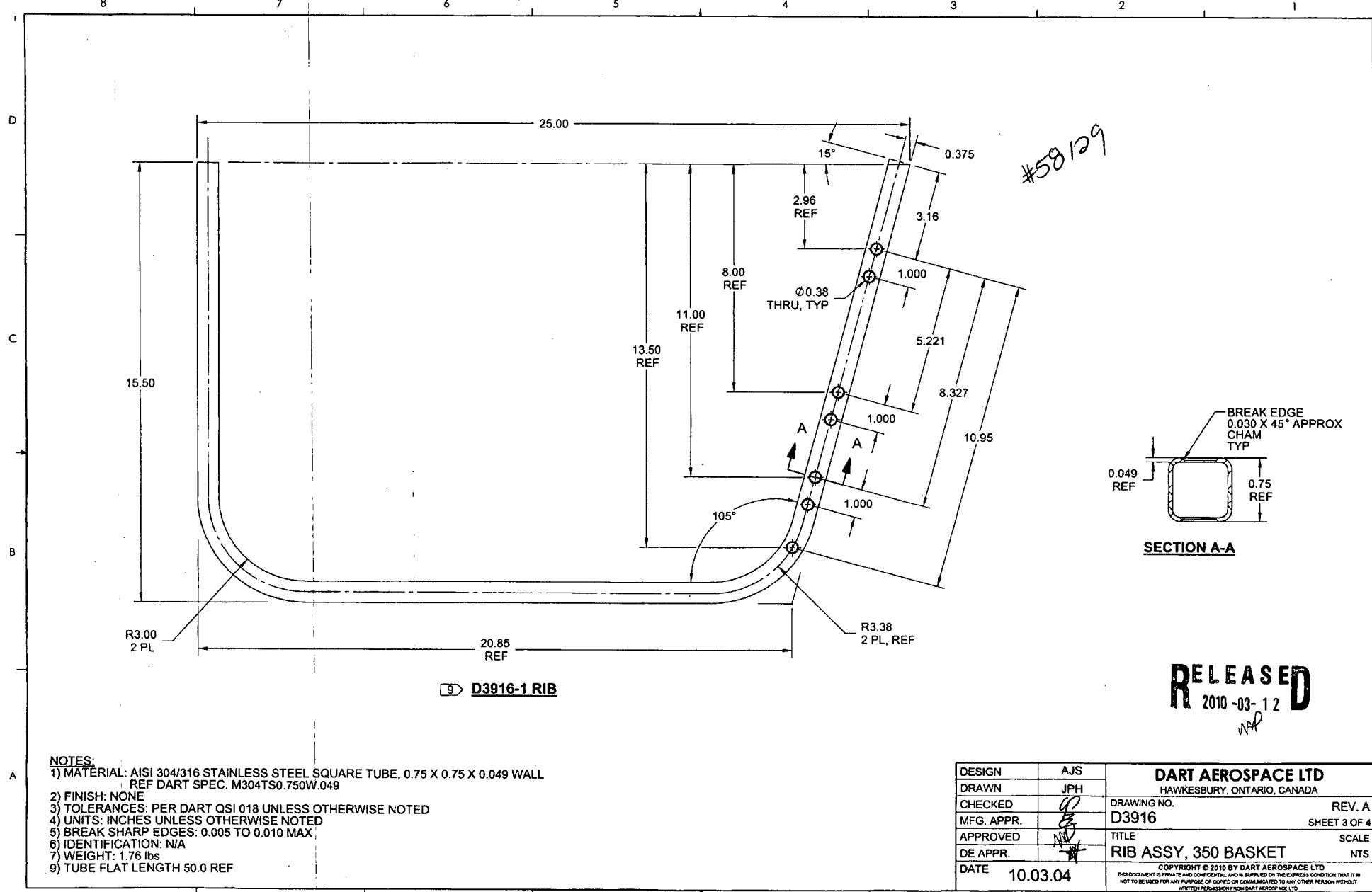
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2010-03-12  
JPH

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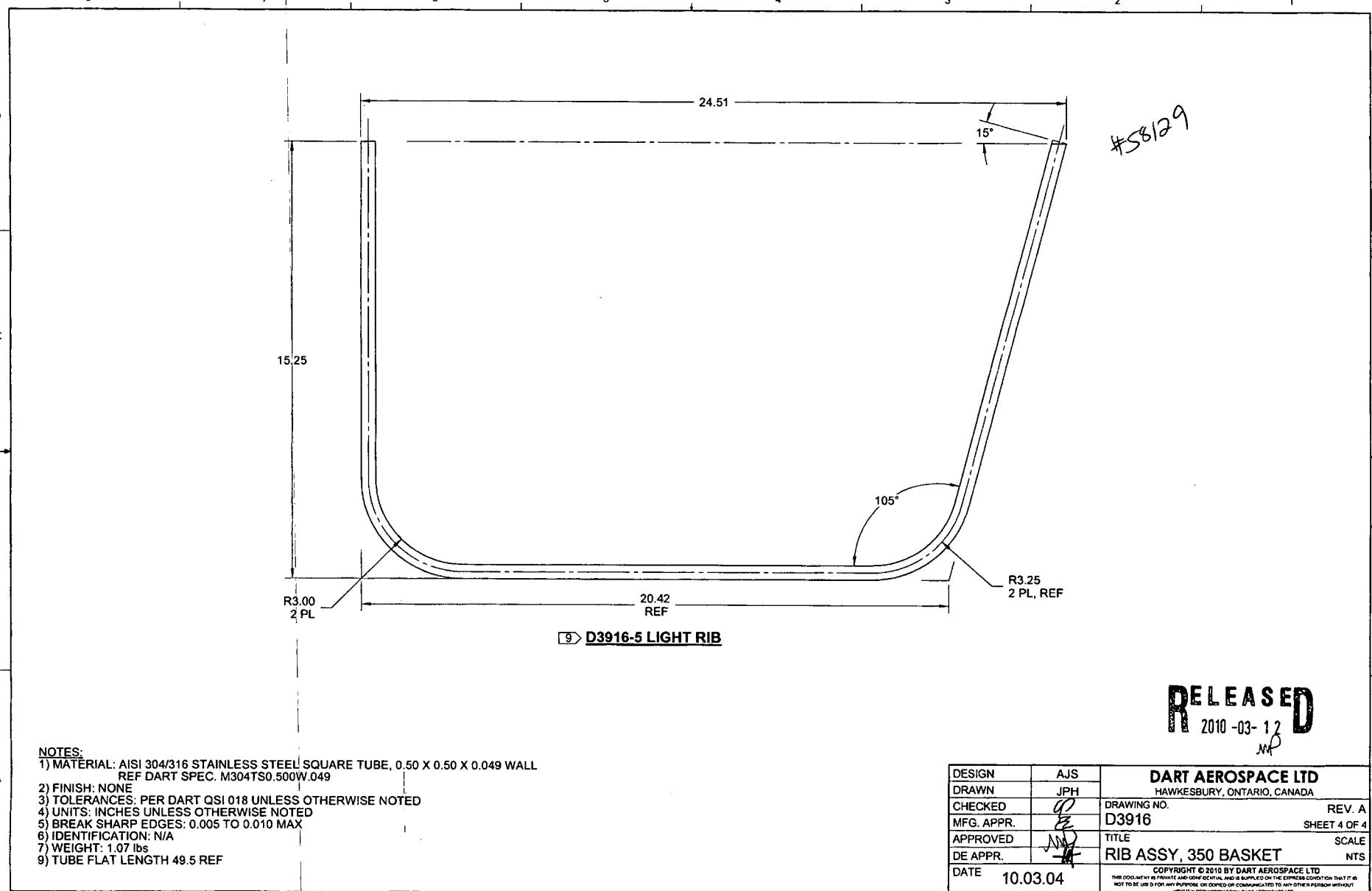
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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